

Work Order ID 83977

Monday, April 30, 2012 3:24:50 PM

83977

Ship ~~may~~ ^{Ship But} ~~16~~ ^{May 16} Page 1

Item ID: D2330-041
Revision ID:
Item Name: Basket Base Assembly

Accept

N9000040100

Setup Start ***NS1***
Stop ***NS2***

Start Date: 5/4/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/25/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: mf Date: 12-0430

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2330	Rev H
-------	-------

100

0.00

100

Large Fab

Memo

0.00

Large Fab

1- weld as per dwg D2330 and QSI 004

S.S Rod batch: 118366

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

120

QC5- Inspect part completeness to step on W/O

0.00

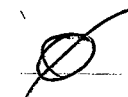
120


QC

Memo

0.00

Quality Control

1x  06.05.16

 06.05.16



Work Order ID 83977

83977

Page 2

Monday, April 30, 2012 3:24:50 PM

Item ID: D2330-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Basket Base Assembly
Start Date: 5/4/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/25/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125	Pressure Wash per QSI005 4.3	0.00							
125									
HandFinish	Memo	0.00							
Hand Finishing									
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	Start Time: 9:15 Oven Temperature: 400°F Finish Time: 9:45								
QC3- Inspect Part Finish		0.00							
140									
QC	Memo	0.00							
Quality Control									

1 2/6 12-5-16
M/L
IX 12/05/17
1 0 12-5-17

Work Order ID 83977

Monday, April 30, 2012 3:24:50 PM

83977

Page 3

Item ID: D2330-041	Accept	*N900040100*	Setup Start	*NS1*
Revision ID:			Stop	*NS2*
Item Name: Basket Base Assembly				
Start Date: 5/4/2012	Start Qty: 1.00	*1*		
Required Date: 5/25/2012	Req'd Qty: 1.00	*1*		
Reference:				
		Cust Item ID:		
		Customer:		

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run Start	*NR1*
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>D200-546-013.</u>								
150									
Packaging	Memo	0.00				1	0		<u>BL 12-5-17</u>
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							<u>MLC 12/05/17</u>
Quality Control									<u>MF</u> <u>12-05-17</u>

Picklist Print

Monday, April 30, 2012 3:24:48 PM

Page 1

Work Order ID: 83977

Parent Item: D2330-041

Parent Item Name: Basket Base Assembly

Start Date: 5/4/2012

Required Date: 5/25/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H02.09.04M304EX0.75-16F was M750-16FXS-S/SKJ
IPP Rev:I 08-09-09 revF as per dwg (ecn 08-522) DD verF by:EC
IPP REV:J 10.11.30 AS PER DWG REV.H DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2012-107 Clevis		Manufactured	No			100	Each	24.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST		24							
				82039		24							
D2235-1 Basket Rib		Manufactured	No			100	Each	19.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		14							
				78636		5							
				81910		9							
				WA005		5							
				66895		4							
				79153		1							
D2252-1 Frame		Manufactured	No			100	Each	4.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		4							
				58084		4							
D2252-7 Frame		Manufactured	No			100	Each	3.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		3							
				73201		3							
D2253-1 Lug		Manufactured	No			100	Each	13.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		13							
				53965		13							

Picklist Print

Monday, April 30, 2012 3:24:48 PM

Page 2

Work Order ID: 83977

Parent Item: D2330-041

Parent Item Name: Basket Base Assembly

Start Date: 5/4/2012

Required Date: 5/25/2012

Start Qty: 1.00

Required Qty: 1.00

D2254
Gussett

Manufactured No

100 Each 44.0000

2

2

PL 12.05.16

Location

Loc Qty

Loc Code

WA005

44

39801

44

D2327-3
Spacer Bushing

Manufactured No

100 Each 17.0000

1

1

PL 12.05.16

Location

Loc Qty

Loc Code

WA

13

82706

13

WA005

4

75564

1

77229

1

81144

2

D2330-1
Frame

Manufactured No

100 Each 2.0000

2

2

PL 12.05.16

Location

Loc Qty

Loc Code

WA

2

75817

2

D2330-5
Frame

Manufactured No

100 Each 3.0000

1

1

PL 12.05.16

Location

Loc Qty

Loc Code

WA

3

75818

3

D2330-7
Frame

Manufactured No

100 Each 0.0000

1

383980 -> 1 PL 12.05.16

Monday, April 30, 2012 3:24:49 PM

Shop Packet Print

Page 2

Picklist Print

Monday, April 30, 2012 3:24:49 PM

Page 3

Work Order ID: 83977

Parent Item: D2330-041

Parent Item Name: Basket Base Assembly

Start Date: 5/4/2012

Required Date: 5/25/2012

Start Qty: 1.00

Required Qty: 1.00

D2581
Mounting Bracket

Manufactured No

100 Each 88.0000

4

4

PL 12-05-16

Location

Loc Qty

Loc Code

WA 5
82506 5
WA005 83
70766 2
81253 1
82017 40
82897 40

4

D3748-1

Hinge Half

Manufactured No

100 Each 17.0000

3

3

PL 12-05-16

Location

Loc Qty

Loc Code

WA005 17
68884 5
76280 12

3

M304EX0.75-16F

Expanded Metal Flat SS

Purchased No

100 sf 1,037.7169

30

30

SAD 12-05-17

Location

Loc Qty

Loc Code

MAT 80.8585
121347 80.8585
WA 254.0001156
119180 0.0001156
121471 254
WA035 702.8582641
117197 102.9036
117896 29.49258
118153 76.8473
118955 82.17
119180 53.6958107
119729 28.1132686
120153 2.97557478
120917 120.52013
121082 14.14
121521 192

Monday, April 30, 2012 3:24:49 PM

Shop Packet Print

Page 3

121471

Picklist Print

Monday, April 30, 2012 3:24:49 PM

Page 4

Work Order ID: 83977

Parent Item: D2330-041

Parent Item Name: Basket Base Assembly

Start Date: 5/4/2012

Required Date: 5/25/2012

Start Qty: 1.00

Required Qty: 1.00

D3833-1
Mesh (Base End Face)
(mesh end caps)

Manufactured

No

100

Each

13.0000

2

2

PL 12.05.16

Location

Loc Qty

Loc Code

WA

5

77521

5

WA035

8

81259

8

2

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2330-041	BASKET ASSEMBLY
3		X	D2330-043	LID ASSEMBLY
7	1		D2012-107	CLEVIS
8	4		D2235-1	RIB
9	2	2	D2252-1	FRAME
10	1	4	D2252-7	FRAME
11	2		D2253-1	LUG
12	2		D2254	GUSSET
13	1	1	D2327-3	BUSHING
14		1	D2329	LABEL PLATE
15	2	2	D2330-1	FRAME
16	1		D2330-5	FRAME
17	1		D2330-7	FRAME
18		1	D2330-15	FRAME
19	4	2	D2581	MOUNTING CHANNEL
20	3		D3748-1	HINGE HALF
21		3	D3749-1	HINGE HALF

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

#83977

RELEASED
2010-11-25

H	DIM 0.50 WAS 0.75 (ZN D2-3 & D6-3) REF NCR 10-346	JPH	10.09.28
G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 20 AND 21 REPLACE D2232-1/-3; STRETCHED LID FROM 83.27" TO 84.00"; ITEMS 9 & 10 REPLACE D2330-3/-9/-13; ITEM 13 (ON LID) REPLACES D2327-1; REORGANIZED ALL SECTION & DETAIL VIEWS. REASON: SEE PAR#09-006.	MB	09.02.05
F	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 6 ADDED. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1. D2253-1 WAS D2253 (NCR 533).	KE	05.11.10
D	MODIFIED LATCH, REDRAWN	KE	99.09.14
C	ADDED LATCH AND LABEL PLATE	BK	96.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JB		
CHECKED	JB	DRAWING NO.	REV. H
MFG. APPR.	JB	D2330	SHEET 1 OF 6
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	BASKET ASSEMBLY (206B)	NTS
DATE	10.09.28	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

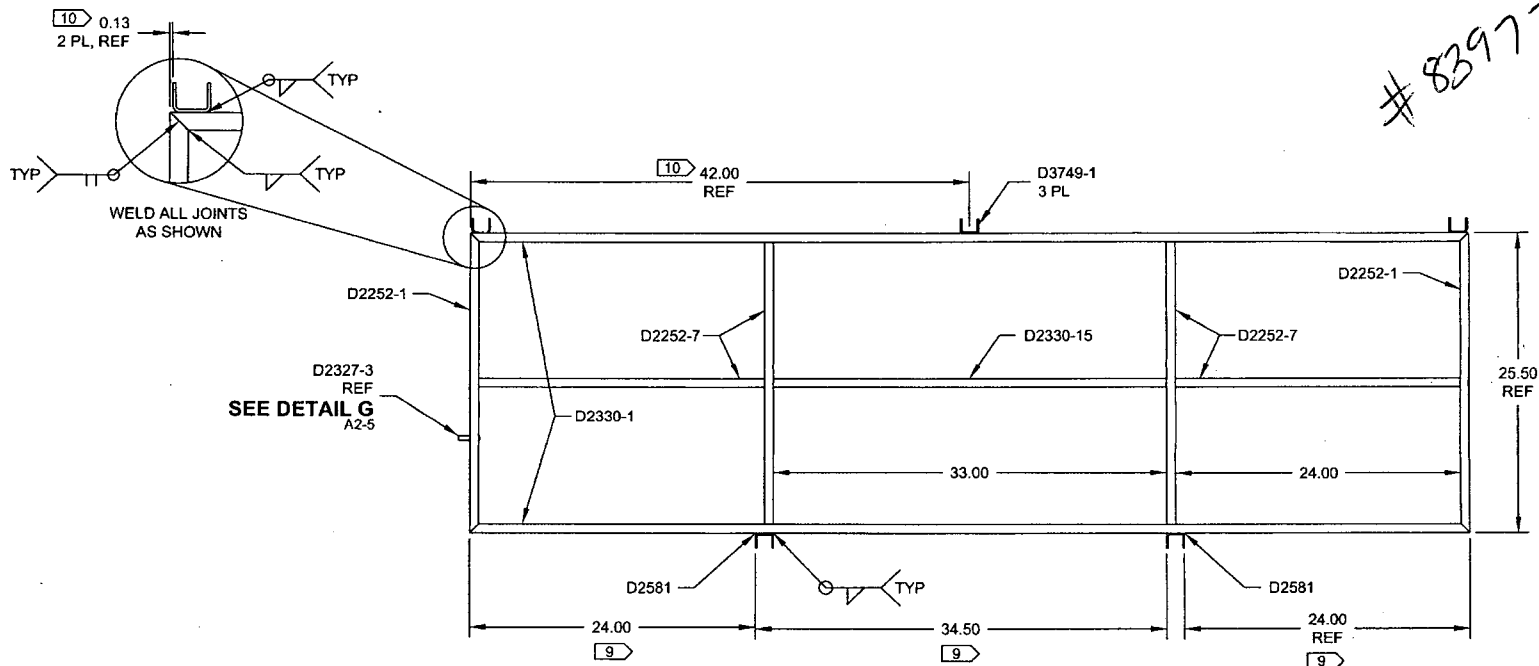
W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			




NOTE: Date & initial all entries



LID FRAME NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) ALIGN WITH ADJACENT D2581 ON BASE
- 10) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF LOCATED ON D2330-041 BASKET BASE ASSEMBLY

D2330-043 LID FRAME

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2330	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
DATE	10.09.28	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

RELEASED
2010-11-25

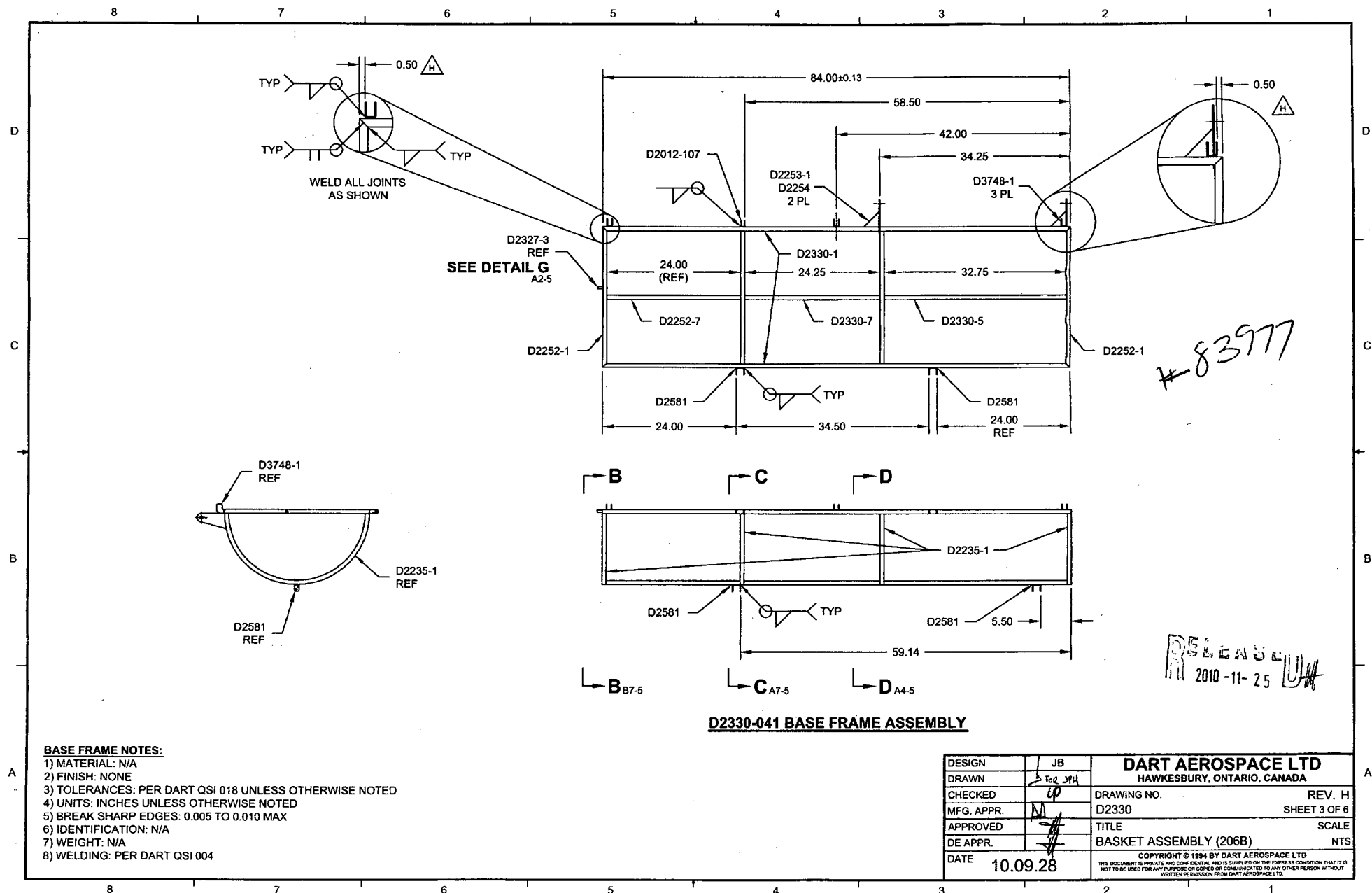
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



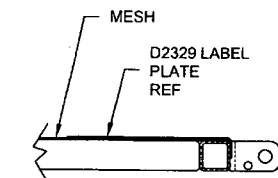
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

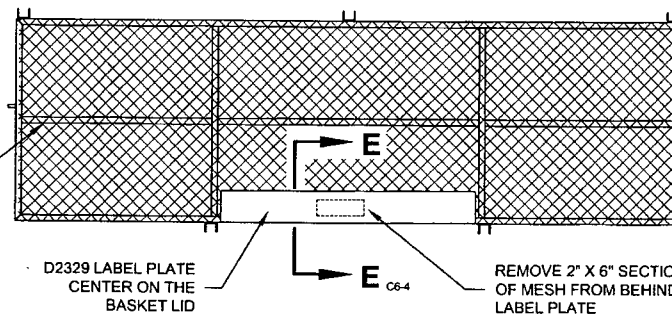
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

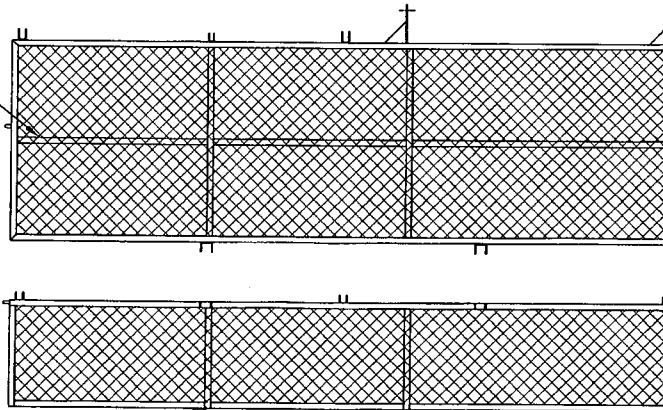


SECTION E-E C3-4
VIEW ROTATED 90° CCW

TACK WELD EACH
STRAND END OF
MESH TO FRAME



D2330-043 LID ASSEMBLY



D2330-041 BASE ASSEMBLY

TRANSFER MARK FROM D3749-1
HINGE HALF ON D2330-043 LID ASSY,
DRILL Ø0.261 THRU

0.200 PRIOR
TO DRILLING Ø0.261 HOLE
THRU D3748-1 AND D3749-1




D3748-1
3 PL, REF

D2330-043
REF

TRIM MESH LOCALLY
AS REQUIRED

ASSEMBLY NOTES:

- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2330	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
DATE	10.09.28	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

#83977

RELEASED
2010-11-25

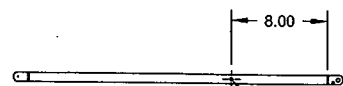
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

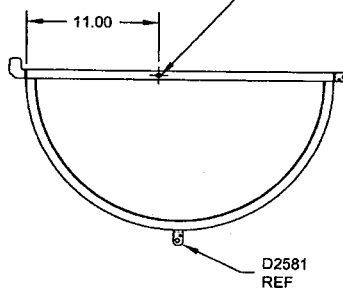
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

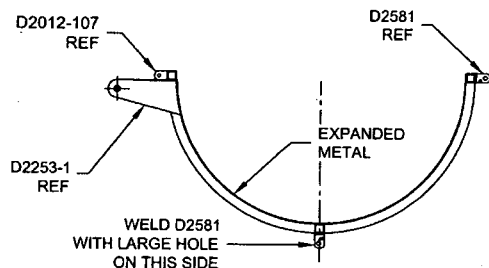


VIEW A-A A6-2

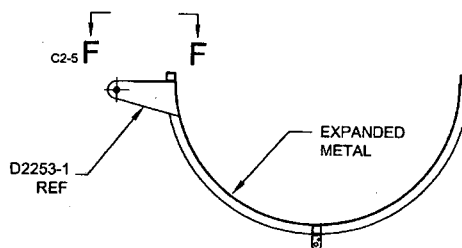
DRILL 3/8 HOLE AND
INSTALL D2327-3
SEE DETAIL G A2-5



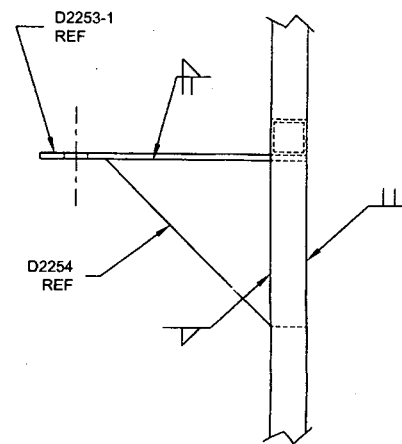
VIEW B-B A5-3



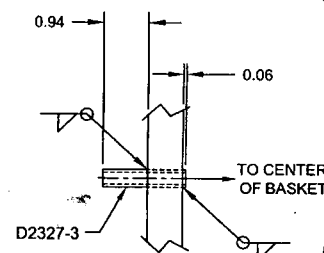
SECTION C-C A4-3



SECTION D-D A3-3



VIEW F-F B6-5
SCALE 4X



DETAIL G
SPACER INSTALLATION
SCALE 4X

RELEASED
2010-11-25

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	D. F. J. P. H.	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2330	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
DATE	10.09.28	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

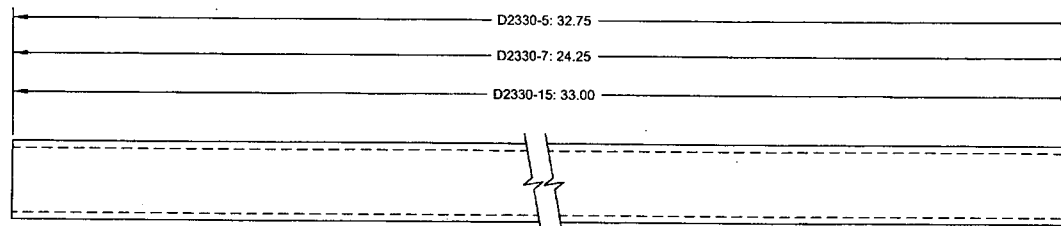
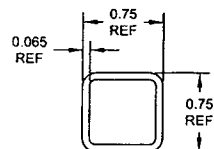
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

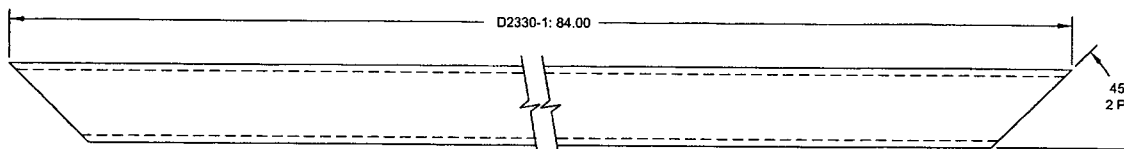
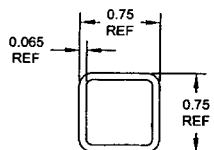
8 7 6 5 4 3 2 1

D



D2330-5 FRAME
D2330-7 FRAME
D2330-15 FRAME

C



D2330-1 FRAME

83977

RELEASED
2010-11-25

NOTES:

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2330	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
DATE	10.09.28	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

A

A

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries